

Date: Tuesday, 27/05/2008 2:46:45 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKIDTUBE ASSEMBLY
Job Number :	39517		
Estimate Number :	10022		
P.O. Number :		Part Number :	D205634011
This Issue :	27/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	N/A
Previous Run :	39516	Drawing Revision :	N/A
	Type :	Material :	
	SKIDTUBES	Due Date :	10/06/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JUD 08.5.27		
Comment :	Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011

CHG005

S 08/06/11

JLD 08.5.30

2.0	39517A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY
 D205-634-041 B

39517 A

SD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	K10003	Saddle, D205-634-011
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K2

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	38049

8/6/11

SP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS

S 08/06/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 27/05/2008 2:47:03 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 39517A
 Estimate Number : 10023
 P.O. Number :
 This Issue ☒ : 27/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205634041
 First Issue : / / Type : SKIDTUBES Drawing Number : D2580 REV D
 Previous Run : 39516A Project Number : N/A
 Material :
 Due Date : 10/06/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 08.5.27
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step
 30 KJ
 Est Rev: O 06.02.28 Added paperwork EC
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2500-1-190 Skid Tube Extrusion

B-37544/AWM 8-5-27

3.0 D2596 Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2596 205 Web

B-39538 AWM 8-5-29

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

AWM 8-5-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/05/2008 2:47:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39517A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/06/05 (1X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/05 (1X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M.L. 08/06/05 (1X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30 a.m.
320°F
9:00 a.m.

M.L. 08/06/09 (1X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/10 (1X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

038395

FL

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

m100188

FL 08/06/11 (1X)

Diagram illustrating the cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing showing a bolt assembly. The drawing includes a circular cross-section of a component with a central hole. A bolt is shown passing through the hole. The following dimensions and callouts are present:

- $\phi 0.208$: Dimension of the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES): Callout pointing to the central hole.
- SEAL WITH SIKAFLEX-241/-291: Callout pointing to the area around the bolt head.
- AN3-5A BOLT (1): Callout pointing to the bolt.
- AN96QJD10L WASHER (1) (2 PLACES): Callout pointing to the washer.
- D2855 CAP: Callout pointing to the cap.
- 0.40: Dimension of the cap.

5

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

HULL ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 1.5 D P P P P P P P

8

REFER TO DETAIL C





D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

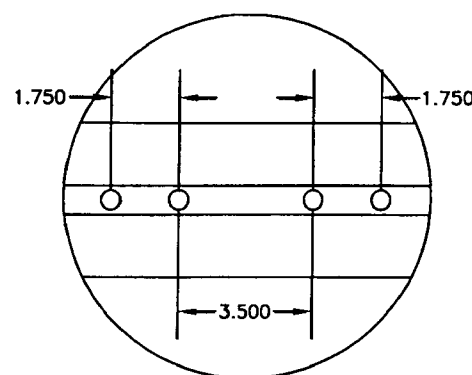
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	DRAWN BY
11	[REDACTED]

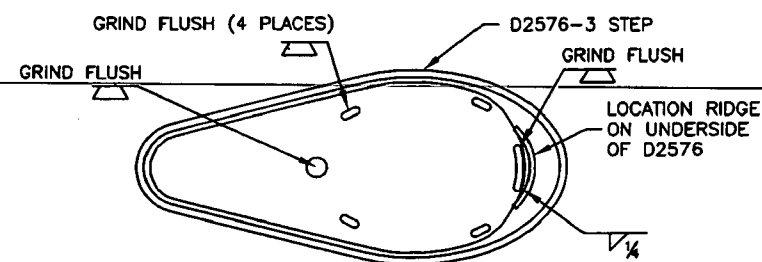
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	CHECKED 	APPROVED 	DRAWING NO. D2580	REV. 1 SHEET 2 OF 3
	DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:2

DETAIL E
SCALE 5:24

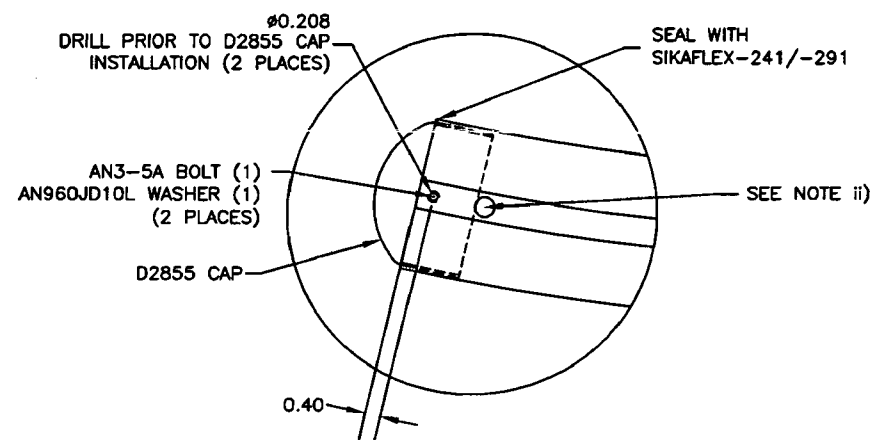


DETAIL F
SCALE 5:24

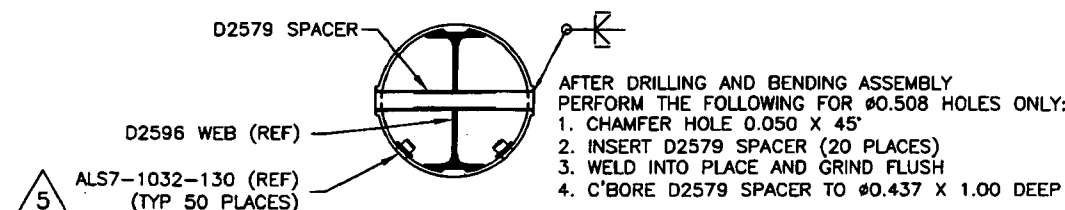


RELEASED
07.02.27

DETAIL G
SCALE 5:24



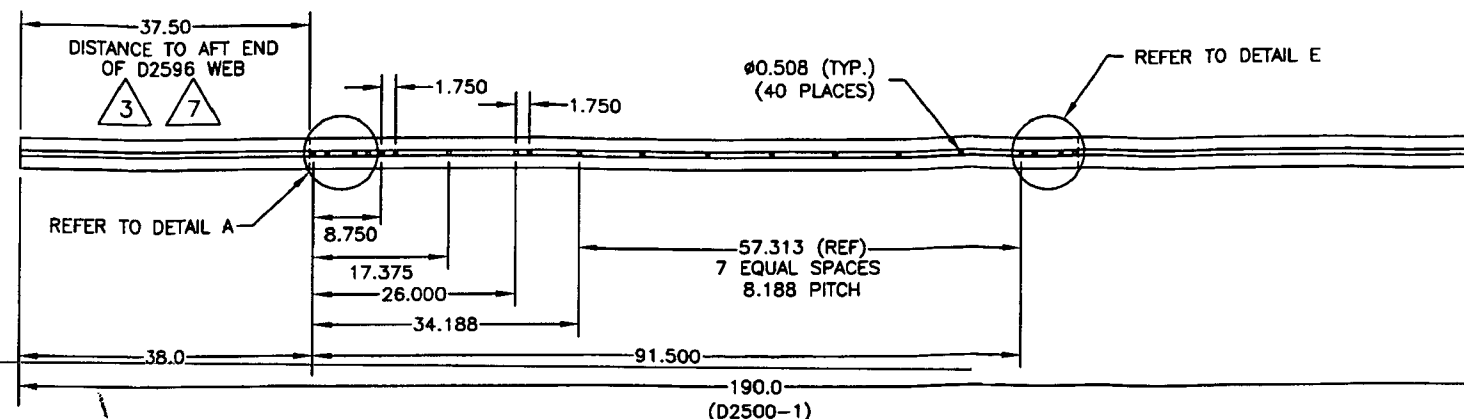
SECTION H-H
SCALE 5:24



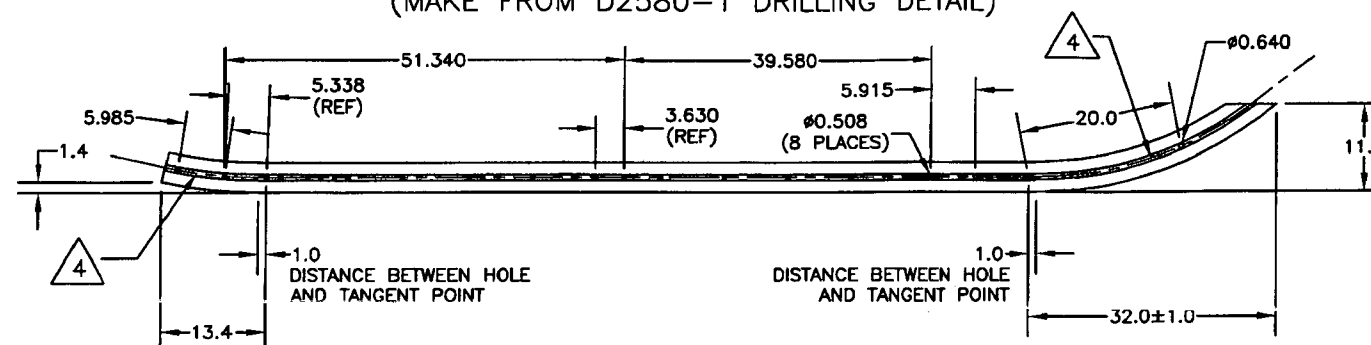
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

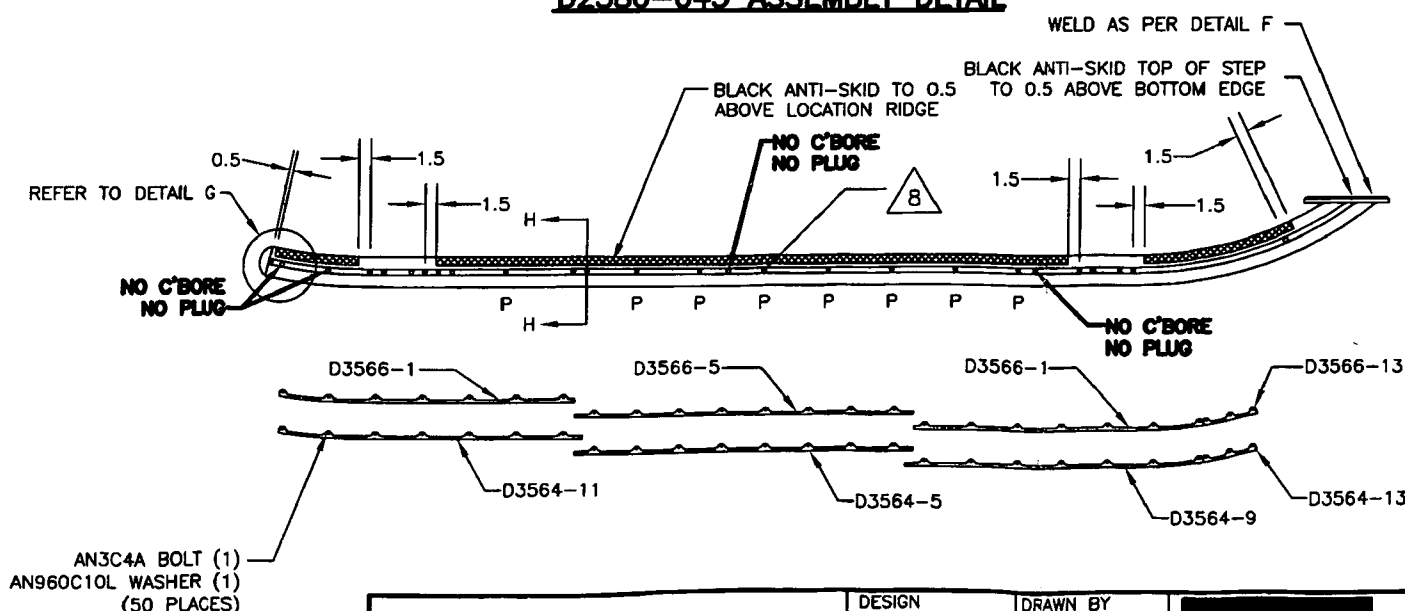
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

